

Work Order ID 72548

Thursday, July 28, 2011 3:09:06 PM

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Item ID: D2617-5

Accept

Revision ID:

Item Name: Spacer

Start Date: 7/28/2011 Start Qty: 20.00

Required Date: 8/3/2011 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2617

Rev D2

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Machine as per Folio FA438 and Dwg D2617-2-Deburr

11/8/2

20 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/8/2

20 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

20 11-8-2

20 0

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Item ID:	D2617-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Spacer					
Start Date:	7/28/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	8/3/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				20	0	11/08/02	
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				20	X	11/08/02	
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>19</u> Memo	0.00 0.00						11/8/25	(20)

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Item ID: D2617-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 7/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/03

11-08-2
(20)

Picklist Print

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Work Order ID: 72548

Parent Item: D2617-5

Parent Item Name: Spacer



Start Date: 7/28/2011

Required Date: 8/3/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP ☐ H ☐ 04.07.14 ☐ Reformat; added step 5 ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.058		Purchased	No			100	f	131.8000	0.0195	0.410526			
6061-T6 RD Tube .500 x.058W													

Location

MAT014

117084

Loc Qty

131.8

131.8

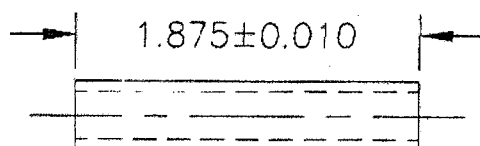
Loc Code

SA 11/8/12
6 R7

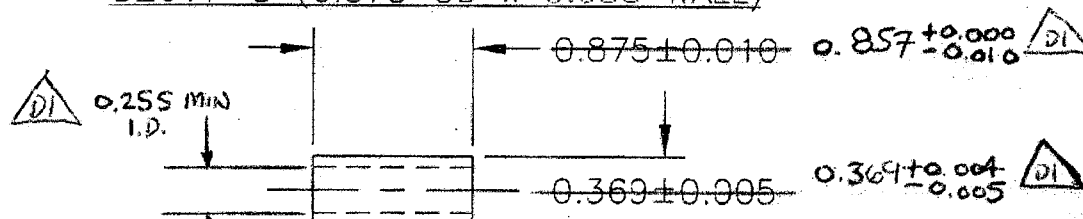


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA			
CHECKED	#	APPROVED	#	DRAWING NO.	REV. D
				D2617	SHEET 1 OF 1
DATE		TITLE		SCALE	
01.07.04		BUSHING		1:1	
D2	04.09.10	CP	ADD D2617-7	A	96.10.08 NEW ISSUE
				B	97.05.08 .875 WAS 1.125
				C	97.06.04 0.369 DIA WAS 0.375
				D	01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE
				D1	04.07.12 CORRECT TOLERANCE (NCR 779)

D2617-1 (0.375 OD x 0.058 WALL)

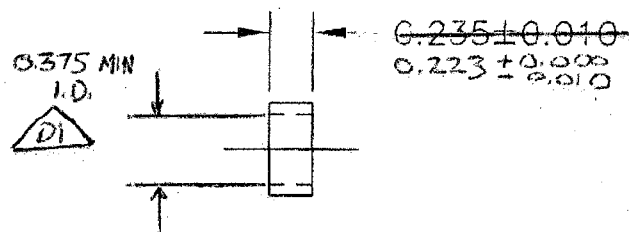


D2617-3 (0.375 OD x 0.058 WALL)



D2 D2617-7 → SAME AS D2617-3 EXCEPT MADE FROM DELRIN (M-DELRIN-R)

D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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